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BEUTHLING

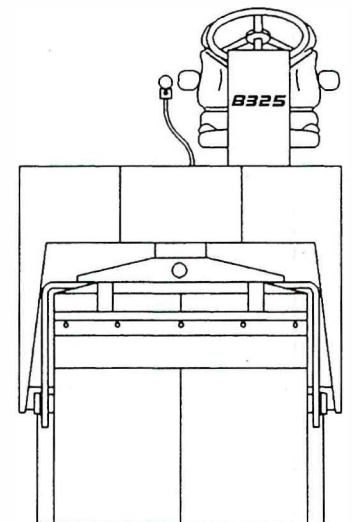
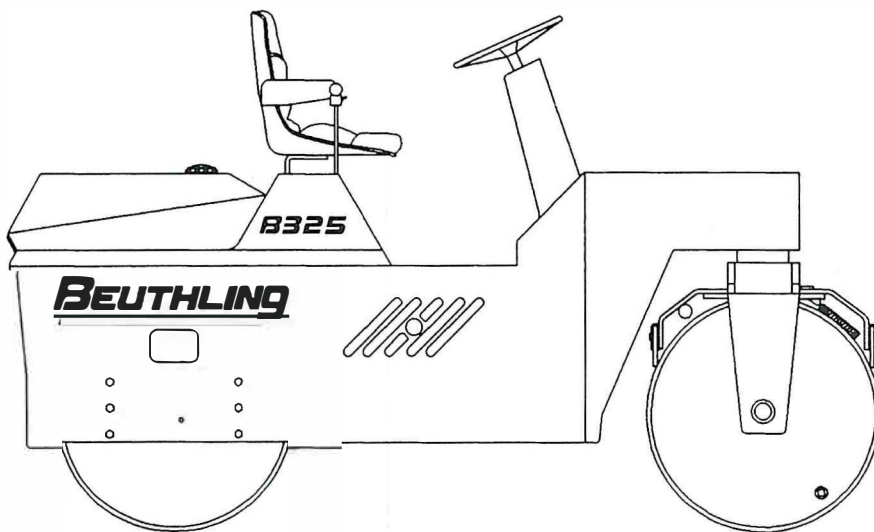
OWNER'S MANUAL
PARTS MANUAL

B325
STATIC

RIDE-ON STATIC COMPACTOR - 3 TON

B325 S/N 325100 & UP

GASOLINE & DIESEL ENGINES




WARNING! READ THIS MANUAL AND  CIMA
ROLLER COMPACTOR SAFETY MANUAL BEFORE
OPERATING OR SERVICING YOUR MODEL B325.

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NOTE:

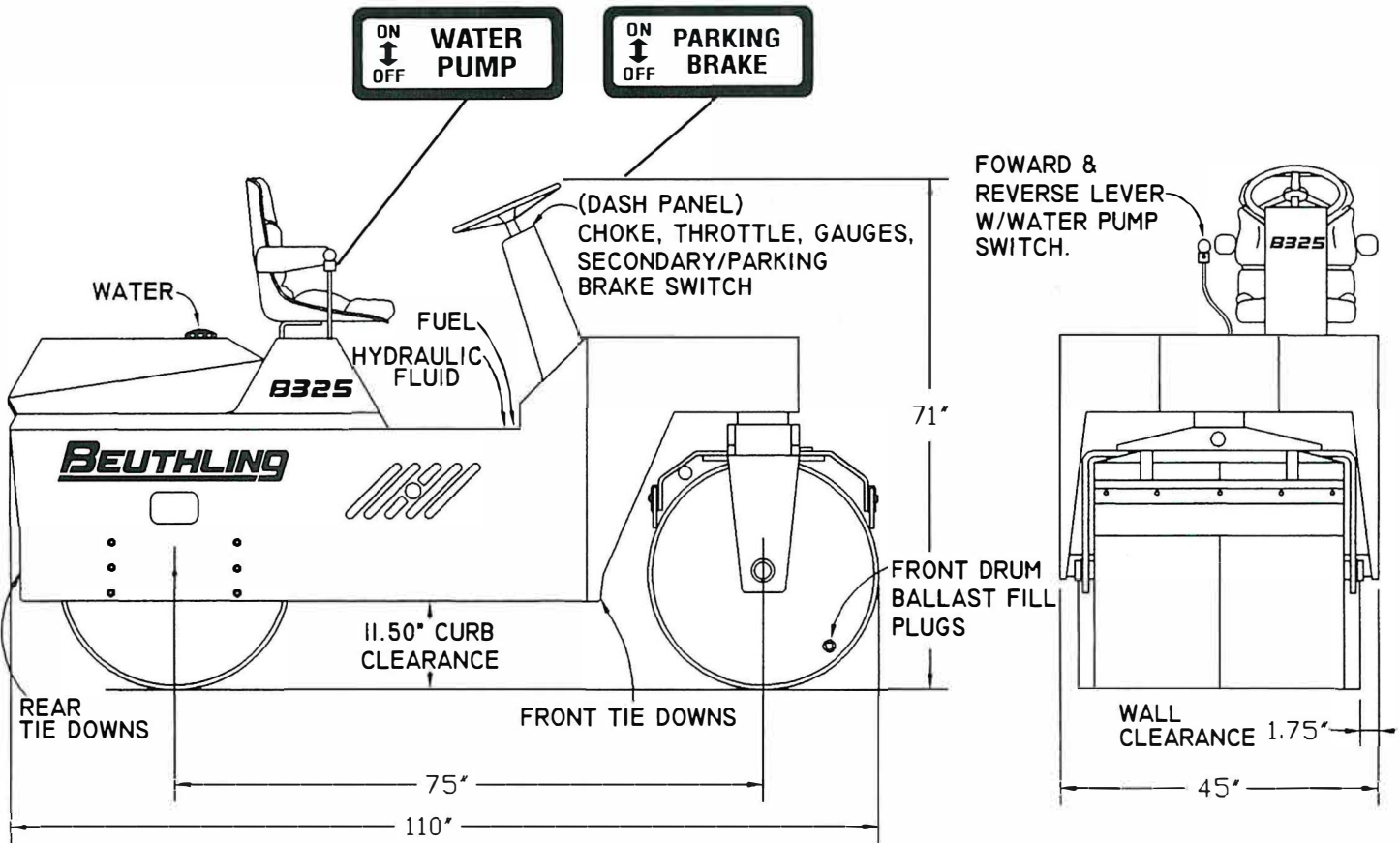
FOR ALL INQUIRES PLEASE INDICATE:

MACHINE MODEL

SERIAL NUMBER

ENGINE TYPE

(MODEL & SERIAL NUMBER PLATE IS LOCATED ON FRONT MAIN FRAME)



OPERATION



WARNING:

Read this manual and the CIMA "Roller - Compactor Safety Manual", supplied with the machine, BEFORE starting, operating, or servicing the machine.

Before starting engine make certain control lever is in "NEUTRAL" (center) position. The transmission MUST be in the "NEUTRAL" position for the engine to be started. A neutral start switch has been included within the electrical system. The brake toggle switch is located on the console dash panel and is "ON" (or brake applied) when toggle switch is in UP position and "OFF" when toggle switch is in DOWN position.

When brake toggle switch is "ON", red indicator light is LIT and ALARM buzzer is SOUNDING.



WARNING:

The machine MUST NOT move, at ANY time, when the secondary/parking brake toggle switch is in the "ON" (up) position. DO NOT operate the machine, if the machine will MOVE when the secondary/parking brake toggle switch is "ON".

NEVER drive the machine with the secondary/parking brake toggle switch "ON".

When starting, if so equipped, and not previously done, unlock the locks securing the floor and dash covers. Move the dash cover to the stowed position.

SAFETY WARNING

- BEFORE OPERATING UNIT, READ AND UNDERSTAND "OWNER'S MANUAL."
- IT IS THE CUSTOMER'S RESPONSIBILITY TO SUPERVISE, TRAIN AND EDUCATE THEIR EMPLOYEES OR ANY OTHER USER OF THIS EQUIPMENT FOR PROPER OPERATION, MAINTENANCE AND SAFETY.
- KEEP HANDS AND FEET CLEAR WHEN UNIT IS RUNNING OR MOVING.



OPERATING OR PARKING THIS UNIT ON INCLINES, HILLS, RAMPS OR NEAR THE EDGE OF A WORK SURFACE MAY BE DANGEROUS AND CAUSE THIS UNIT TO BECOME UNSTABLE OR ROLLOVER.



ALWAYS BE IN CONTROL OF YOUR UNIT

FAILURE TO OBEY SAFETY WARNINGS MAY RESULT IN SERIOUS INJURY TO OPERATOR OR OTHERS.



CAUTION

If the engine does NOT start within ten (10) seconds of continuous cranking, turn the ignition key switch to the "OFF" position and wait at least thirty (30) seconds. This will allow the starter motor time to cool. Try starting the engine again. Do NOT increase the speed of the engine ABOVE the LOW rpm for a period of one (1) minute, to allow the hydraulic oil to reach operating temperature.

If so equipped with ROPS, IMMEDIATELY, after being seated, place the seat belt across the lap and SECURELY insert the metal end into the belt buckle. TIGHTEN the belt, AGAINST the body, by pulling on the loose end of the belt.

Move the engine speed throttle control to the LOW (down) engine idle speed position. Pull the engine choke knob to the "choke" (up) position, if the engine is cold.

Turn the ignition switch key to the START position. Crank and start the engine. The "green" (on) indicator light, located near the switch, will be lit. If used, push the choke knob "in" as the engine warms. Put the engine throttle speed (RPM) control in the desired engine speed position and turn the throttle control handle clockwise to "lock" in position.



WARNING:

Do NOT put the engine throttle speed (RPM) handle in the "FULL" engine speed position when the machine is being run in a confined area, or is near ANY object.

Check operation of ALL gauges and instruments. Check the operation of ALL other optional equipment, such as rotating beacon and work lights, if so equipped. The machine is put into motion by moving the control lever in the direction of the travel desired. PUSHING the lever in the FORWARD direction will select a FORWARD direction of machine travel. PULLING the lever in the BACKWARD direction will select the REVERSE direction of the machine travel. If so equipped, note that the back up alarm system sounded when the control lever moved within the REVERSE position. The machine travel speed is proportional to the amount of the control lever movement, UNTIL full lever travel has been reached, in EITHER direction. The control lever should be moved slowly from one direction through neutral to the opposite direction. The procedure utilizes the hydraulic system's DYNAMIC BRAKING capability to bring the machine's weight to a complete stop, at neutral, before going in the opposite direction. This procedure allows the transmission system and engine to slow the machine to a stop.

If it is noticed that the engine power decreases when the control lever is fully advanced during a heavy pull, move the control lever back to increase power and decrease "engine lugging".



WARNING:

Slowing or stopping of machine during LEVEL surface operation is done by moving the directional/speed control lever TOWARD, and then TO the NEUTRAL position. Slow, or stop, the machine on a SLOPE, by moving the directional/speed control lever to the direction OPPOSITE the direction of machine travel.

If the machine speed can NOT be controlled through the use of dynamic braking, use dynamic braking AND the secondary/parking brake system to slow, and then stop the machine.

The secondary/parking brake system MUST be used to hold the machine in a "stopped" condition at ALL times. The transmission system will NOT hold the machine in a "stopped" condition.

STARTING THE ENGINE (DIESEL)

- (1) Set the fuel cock to "ON". (at Engine)
- (2) Check that the engine stop cable is in the original pushed in position.
- (3) Place the speed control lever at low RPM.
- (4) Insert the key into the starter switch, and turn it to "ON".
- (5) Check to see that the oil pressure lamp and charge lamp are on.
- (6) Turn the starter switch counterclockwise to "PREHEAT" to allow the glow lamp to light up. Shown below are the standard preheating times for various temperatures. This operation, however, is not required, when the engine is warmed up.

The glow lamp goes out in about 5 seconds when the lamp timer is up. Refer to this for pre-heating.

Even with the glow lamp off, the glow plug can be preheated by turning the starter switch to the "PREHEAT" position.

Temperature	Preheating Time
Over 10°C (50°F)	About 6 sec.
Below -5°C (23°F)	About 10 to 15 sec.

- (7) Return the key to "START", and the starter will begin turning, starting the engine. Release the key immediately.
- (8) Check to see that the oil pressure lamp and charge lamp are off. If not, immediately stop the engine, and check the cause (see Engine Manual).
- (9) Warm up the engine at low speed.
- (10) Check to see that the oil pressure lamp is off. If it should stay on, immediately stop the engine and check.
 - * if there is enough engine oil.
 - * if the engine oil has dirt in in it.
 - * if the wiring is faulty.

Maintain low R.P.M. for approximately (1) minute to allow hydraulic system to warm up, move parking brake toggle switch to the off position before moving unit. Travel speed and direction of travel are controlled by the control lever, next to seat.

Check gauges, instruments and warning lights frequently to assure that they are functioning and their readings are within the operating range.

STOPPING ENGINE: (Diesel)

- (1) Move directional/speed control lever to **neutral position**.
- (2) Set engine **throttle handle** to **idle** position. (Down)
- (3) Set **parking brake switch** to ON position.

- (4) Pull **stop cable** and hold until engine stops.
- (5) Turn **ignition key** counterclockwise to **off position** and remove from switch. Do not turn ignition key to off position until engine stops. Spring actuated brakes **will not** be applied with ignition switch on.
- (6) Push to return **stop cable** to start/run position for next engine starting.

EMERGENCY SHUTDOWN PROCEDURE: (Diesel Engine)

- (1) Move directional/speed control lever to **neutral position**.
- (2) Stop engine by pulling engine **stop cable**.
- (3) Turn **ignition key** counterclockwise to **Off Position** and remove from switch. Parking Brake is spring actuated when engine is stopped and Ignition Switch is turned off.

See Kubota Engine Owners Manual for additional details on engine operation.

DYNAMIC BRAKING

Hydrostatic drive motor in rear drum provides hydraulic dynamic braking when the directional/speed control lever is moved to neutral.

SECONDARY / PARKING BRAKE:

Failsafe, mechanical disc brakes in the hydrostatic drive motor are spring actuated when engine is stopped. Brake is hydraulically released when engine is started. Manual parking brake switch on console controls solenoid hydraulic valve which actuates, and releases secondary/parking brake when engine is running. Manual switch in “OFF” position releases brakes, and in “ON” position actuates brakes.



WARNING:

Do Not try to move machine with secondary parking brake engaged. Backup pressure of hydraulic system with low engine RPM's may have adverse affects on engine and hydraulic system if this happens.

The B325 is equipped with a **Towing Bypass Valve** and a **Manual Brake Release** to allow the compactor to be moved short distances at low speeds without engine running. When towing this compactor without engine running, the following procedure must be carefully followed:

- (1) Connect towing vehicle to compactor, make sure towing vehicle is headed uphill if compactor is located on an inclined surface, and parking brake is set. One roller on compactor should be blocked on both sides to prevent any movement of compactor when crawling under machine to open towing bypass valve.
- (2) **Open towing bypass valves as follows:**
Bypass valves are located on the propel pump, one on top and one on the bottom (Refer to page 21). Bypass valves are integral with the check high pressure relief valve assemblies. **Both assemblies must be opened for bypass operation.** Valves are fully open at

4 REVOLUTIONS COUNTER CLOCKWISE (CCW) **DO NOT OPEN VALVES PAST 4 TURNS.** USE 5/16" INTERNAL HEX WRENCH. TORQUE PLUGS TO (30 TO 50 FT. LBS) WHEN CLOSED.

(3) RELEASE BRAKE MANUALLY ON REAR HYDRAULIC DRIVE MOTOR AS FOLLOWS:

USE BRAKE BOLT, P/N 000-7122, SHOWN ON PAGE 8, ITEM (4). BOLT IS MOUNTED ON DRIVE PLATE ITEM (2) WHEN NOT BEING USED.

- A. INSERT HEX WRENCH THRU HOLE IN RIGHT HAND SIDE FRAME AT CENTER OF DRIVE MOTOR AND REMOVE 1/8 NPT PIPE PLUG. (REFER TO PAGE 21).
- B. INSERT BRAKE BOLT THROUGH SAME HOLE INTO DRIVE MOTOR. TURN BOLT HEX HEAD CLOCKWISE (CW) UNTIL MOTOR BRAKE IS DISENGAGED (1-2 TURNS).
- C. REMOVE BOLT COUNTERCLOCKWISE (CCW) TO RETURN BRAKE TO OPERATING POSITION BEFORE MOVING COMPACTOR BY ITS ENGINE.
- D. RETURN 1/8 NPT PIPE PLUG TO DRIVE MOTOR.



WARNING:

DO NOT OPERATE UNIT WITH HYDRAULIC MOTOR BRAKE MANUALLY RELEASED.



CAUTION:

To prevent the compactor from moving accidentally, do not release the hydraulic motor brake manually until:

- (1) Compactor is connected to towing vehicle.
- (2) Compactor drum is blocked.
- (3) Towing bypass valves must be opened before releasing the hydraulic motor brake manually. Opening the towing bypass valves will remove hydraulic fluid braking force. This will permit the compactor to move when the hydraulic motor brake is manually released.
- (4) Tow compactor at speeds under 2 miles per hour, short distance only, up to 100 ft.
- (5) After compactor has been towed, remove brake bolt from hydraulic motor to activate brake on motor.
- (6) Block both sides of one compactor drum to prevent any movement of compactor when crawling under machine to close the towing bypass valves.
- (7) Disconnect from towing vehicle.



CAUTION:

BEFORE and AFTER towing **APPLY** the secondary/parking brake. Return the towing bypass valve to the “normal operation” (closed) position. Always block drums when machine is stationary with a bypass valve in **FREEWHEEL (OPEN)** position.

WATER SPRAY SYSTEM

The pressurized water spray system will help keep both drums clean when compacting asphalt. Fill the water tank with clean water. Located by the seat are dual water valves. Open these valves, by moving the valve handles, until the desired flow rate is obtained at each drum. Put the water spray system control switch in the "ON" position (located on control lever). The "amber" (on) indicator light on dash will be lit. NEVER run the system dry.

A full width cocoa mat is located on each drum and is used in combination with the water spray system to help keep the drum surface wet and clean.

DRUM SCRAPERS

Both the front and rear drums are equipped with full width, adjustable rubber scrapers which are mounted ahead of, and behind each drum. These scrapers are designed to help keep large pieces of material from clinging to the drums when traveling in either direction. The scrapers must remain adjusted against the surface of the drums at all times.

DRUM BALLAST

This machine is designed for use with or without liquid ballast in the front drums only.

If water ballast is used in temperatures below freezing, use 30% alcohol in water. If fuel oil is used, allow 10% for expansion. A pipe plug is located in each front roller for filling and draining purposes, be sure to fill both front drums.

MACHINE TRANSPORT

When the machine is being moved by truck or trailer, use SOLID wood blocking. Use SOLID wood blocks in front, and at the rear, on EACH side of EACH drum. Four (4) tie-down areas are provided and are to be used, with the blocking, to secure the machine to the truck or trailer bed when transporting the machine. Secure all fill caps and covers before transporting.

MAINTENANCE



WARNING:

DO NOT operate machine if any part is not in proper operating condition or is missing. Always remove key from switch when performing maintenance (engine off), leaving equipment unattended or when equipment is not in use.

ENGINE

Daily check the engine lubrication oil level in the crankcase. The engine lubrication oil MUST be kept at a level ABOVE the "ADD" mark but NOT ABOVE the "FULL" mark on the engine lubrication oil dipstick. A low oil warning indicator "Red" light is located on dash. Check engine oil when lit. Check the engine inlet air cleaner condition and remove and replace as needed.



CAUTION:

See the "Engine Operation and Maintenance Instruction Manual", published by the Kohler or Kubota Engines, for approved, correct engine component inspection and maintenance periods and/or procedures.

HYDRAULIC SYSTEM

After a new machine has run FIVE (5) hours, the oil filter should be changed. This is to rid the system of any trapped contamination from factory assembly. ANYTIME the filter has been changed, IDLE engine for three (3) minutes with control lever in neutral. At the end of this running period SLOWLY engage forward to reverse. This allows fluid to replace the air in the pump area introduced into the system with the filter change. IF THIS PROCEDURE IS NOT FOLLOWED partial or complete failure of the pump will result.

Check hydraulic fluid daily, change fluid and filter every 200 hours or yearly, sooner if conditions warrant, i.e., extreme dust or condensation. The B325 is equipped with a 10 gallon oil reservoir - when changing or adding fluid, use H.D. 32HYD Fluid or Equivalent. To prevent any foreign matter from entering the tank, extreme care should always be used when removing fill cap. Fluid is at proper level when seen at the "middle" of the screen in the fill neck. Never fill reservoir to overflowing.

DIRECTIONAL CONTROL LEVER

Lubricate the directional control lever and cable assembly exposed, and pivoting part areas, with EP-2 chassis grease. NO zerk fitting is found on the directional control lever and/or cable assembly. Inspect the mechanical condition of the control lever and cable assembly. It must NOT be loose, damaged, or bind within the lever, or cable. Repair, or replace, the direction control lever and/or cable assembly if any damage is noted.

FRONT DRUMS

Several times per year, lift the front drums and check for any side movement (end play) of the drums, through the tapered roller bearings. If needed, adjust the movement by loosening the two (2) set screws found on each end of the front axle and tightening the Axle bolts (having grease zerks) to obtain correct end play. Retighten the set screws.

DRUM SCRAPERS/COCOA MATS

Check the condition and adjustment of all four (4) rubber scrapers, if worn beyond adjustment replace with new. NOTE: Rubber scrapers can be removed and flipped to opposite side to extend life. Check and replace both cocoa mats when worn or damaged. Never allow steel pans to come in contact with drum. Front and rear cocoa mats pans are designed to pivot away from drums when not in use.

BEARINGS

Lubricate each of the four (4) front axle bearings through the one (1) zerk fitting found at the left, and (1) zerk on the right end of the front axle shaft with EP-2 chassis grease. Use enough grease through zerk fitting to purge old grease on inner bearings.

All bolts, drive coupling set screws and collar set screws of bearings, should be checked during each periodical maintenance check and lubrication activity.

See lubrication chart in this manual and under center floor cover for complete bearing lubrication.

WATER SPRAY SYSTEM

The water system should be drained when freezing temperatures are expected. Remove drain plug Item (9) to drain tank. Remove Hoses Items (18) and (20) to drain pump and valves. See Water Spray System Diagram page 9.

ELECTRICAL SYSTEM

This system is 12-volt, during engine and other system maintenance inspections, check the electrical wiring for correct routing and support. Inspect the wires for loose terminal connections, cracks or wear in the wiring insulation and for corrosion.



WARNING:

BATTERY EXPLOSION CAN OCCUR IF A BATTERY IS SHORTED. ALWAYS disconnect BOTH the positive (+) AND the negative (-) battery cables from a battery, BEFORE ANY repair procedures are done to the electrical wiring or components. DO NOT weld on machine unless battery is disconnected and removed.

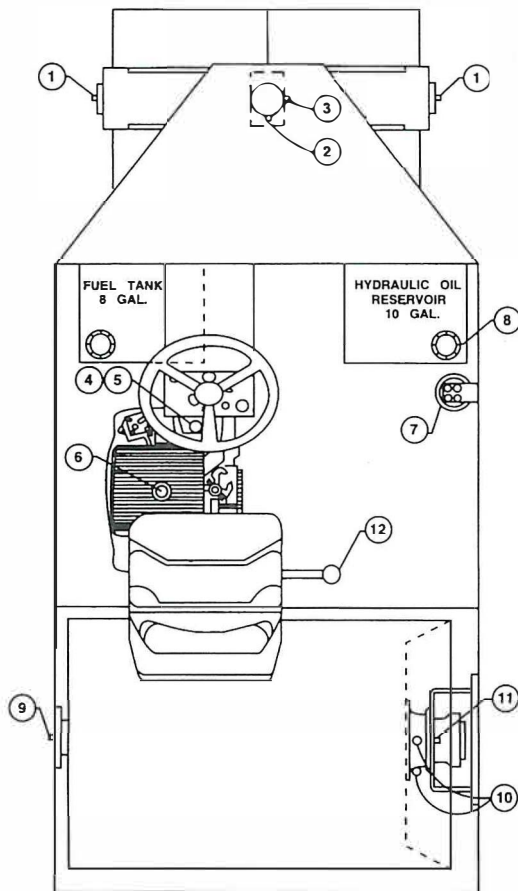
A thirty (30) amp circuit breaker has been installed in the electrical circuit. It is located under the dash. If a circuit overload occurs, the circuit breaker will reset automatically every ten (10) seconds, or until the cause of the overload has been located and corrected.

Gasoline units have three functions monitored by gauges on the dash panel. These functions are: VOLTMETER, HOURMETER and FUEL GAUGE, (Optional). Diesel units have five functions monitored by gauges on the dash panel. These functions are; ENGINE OIL PRESSURE, ENGINE WATER TEMPERATURE, VOLTMETER, HOURMETER and FUEL GAUGE, (optional).

For indicator light functions refer to Operation, pages 1-4.

NEVER attempt to disconnect the hourmeter. Engine and machine operating hours are essential for proper machine maintenance.

LUBRICATION CHART



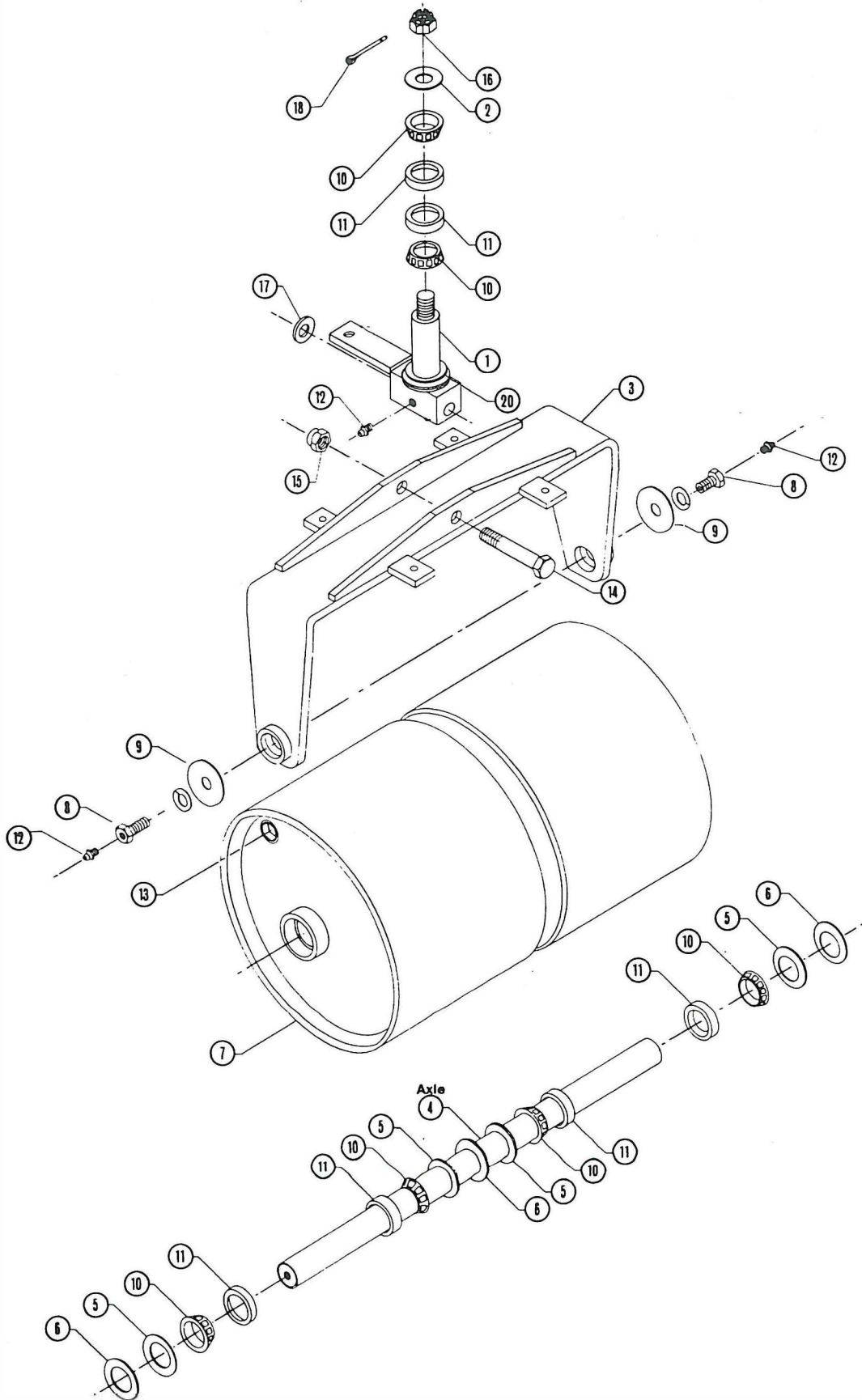
MODEL B325

Ref. No.	Lubrication Point					Types of Lubricant	Grease Fitting
		DAILY	WEEKLY	MONTHLY	230 HOURS		
1	Front Axle Bearings		•			EP-2 Chassis Lub.	Yes
2	Front Pivot Tube Bearings		•			EP-2 Chassis Lub.	Yes
3	Oscillating King Pin Bolt		•			EP-2 Chassis Lub.	Yes
4	Engine Crankcase	✓				See Engine Manual	No
5	Engine Oil Filter	✓				See Engine Manual	No
6	Engine Air Cleaner	✓				See Engine Manual	Yes
7	Hydraulic Oil Filter				•	Replace	No
8	Hydraulic Oil Reservoir	✓				• Sunco TH Fluid or Equivalent-10 US Gal	No
9	Rear Drum Flange Bearing	✓	•			EP-2 Chassis Lub.	Yes
10	Hydraulic Motor			✓		EP-90 Gear Lub.	No
11	Hydraulic Motor Seal				•	EP-2 Chassis Lub.	Yes
12	Control Lever	✓	•			EP-2 Chassis Lub.	No

✓ Check

• Lub. or Change

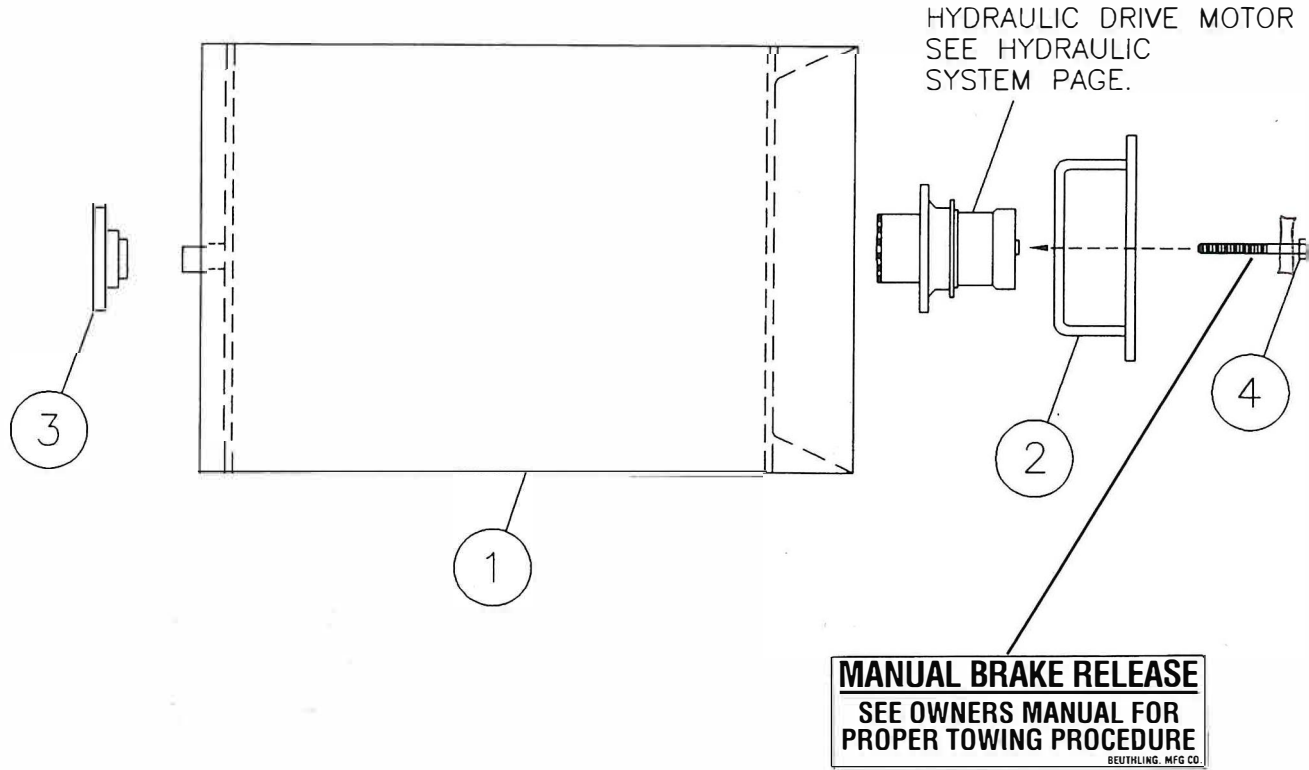
See B325 Owner's Manual For Further Details



FRONT END ASSEMBLY
B325

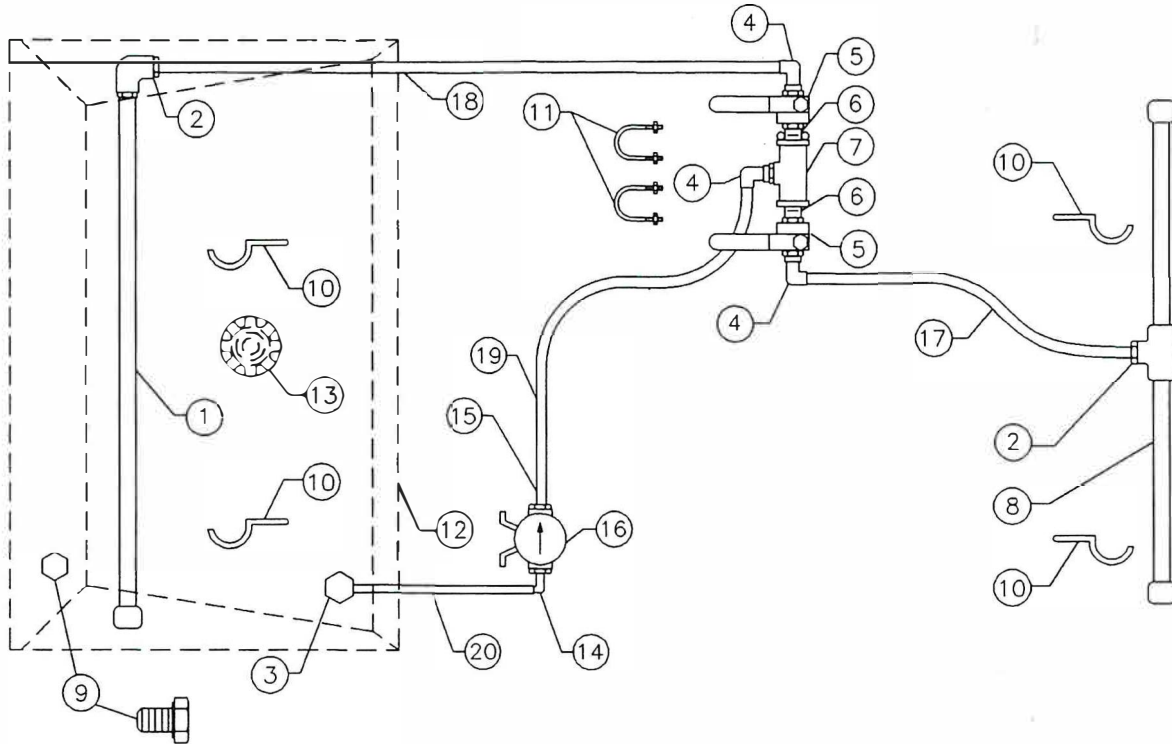
Item No.	Prt No.	Description	Qty.
1	000-7059	King Pin	1
2	000-7063	Washer - King Pin Top.....	1
3	000-7045	Yoke.....	1
4	000-7029	Front Axle.....	1
5	000-7107	Front Axle Grease Seal - Inner & Outer.....	4
6	000-7124	Front Axle Bearing Spacer Set.....	As Required
7	000-7012	Front Drum (halfs)	2
8	000-7109	Front Axle Bolt	2
9	000-7110	Washer - Front Axle.....	2
10	300-0028	Bearing Cone.....	6
11	300-0029	Bearing Cup.....	6
12	370-0001	1/4-28 NF Grease Fitting	3
13	526-0001	1 1/2" NPT Countersunk Ballast Fill Plug.....	2
14	600-9008	King Pin Bolt	1
15	607-0034	Nyloc Nut	1
16	605-0035	Hex Slotted Nut	1
17	000-7122	King Pin Bolt Spacer	As Required
18	630-0018	Cotter Pin	1
19	615-5001	Socket Head Set Screw.....	4
20	000-7062	Washer - King Pin Bottom	1

**REAR DRUM ASSEMBLY
B325**



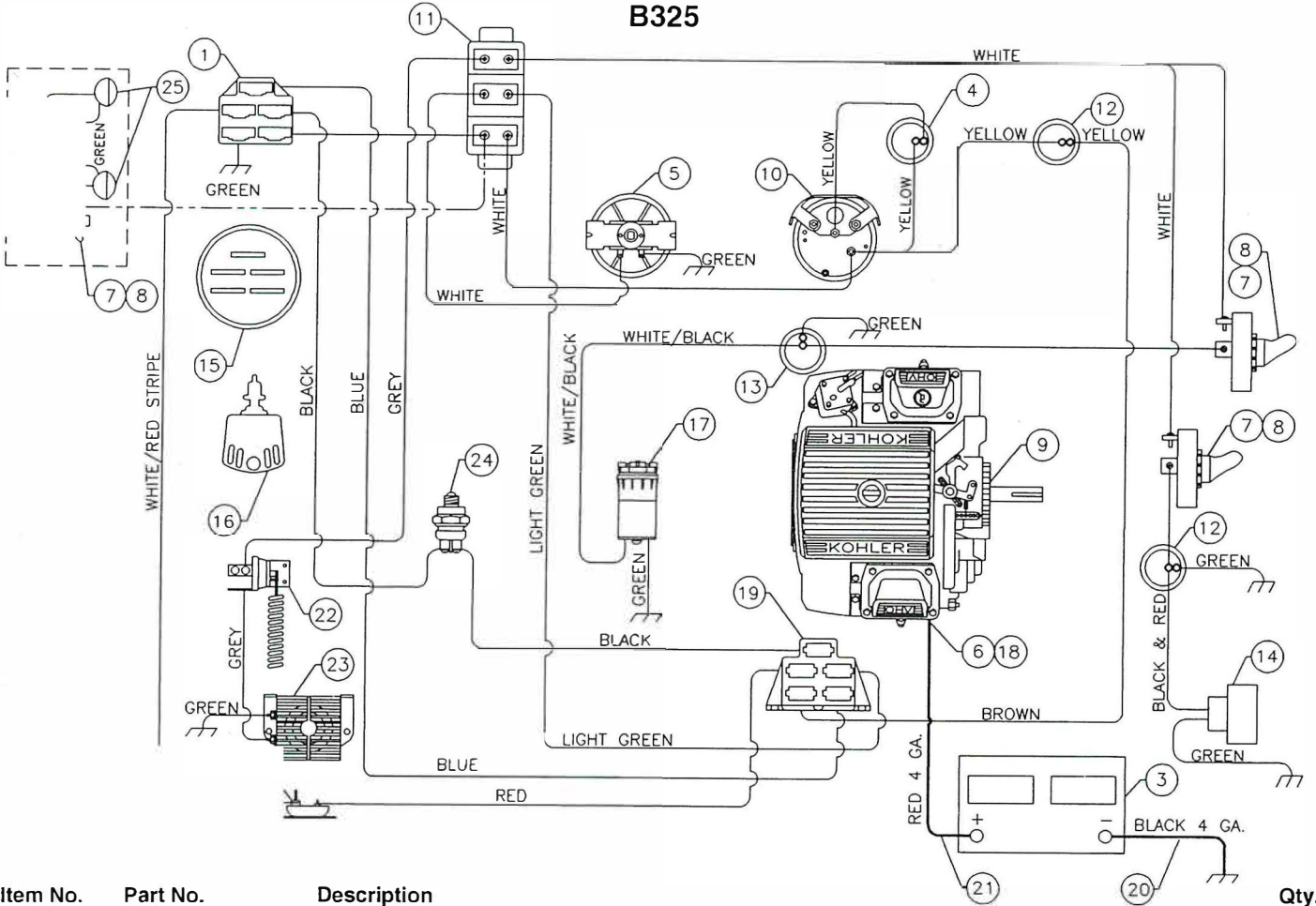
Item No.	Part No.	Description	Qty.
1	000-7023	Rear Drum	1
2	000-7026	Drive Plate	1
3	300-0006	Bearing - Rear Drum	1
4	600-2011	BRAKE RELEASE BOLT (5/16 - 18NC X 2-1/2 LG.) WITH FLAT WASHER	1

**WATER SPRAY SYSTEM
B325**



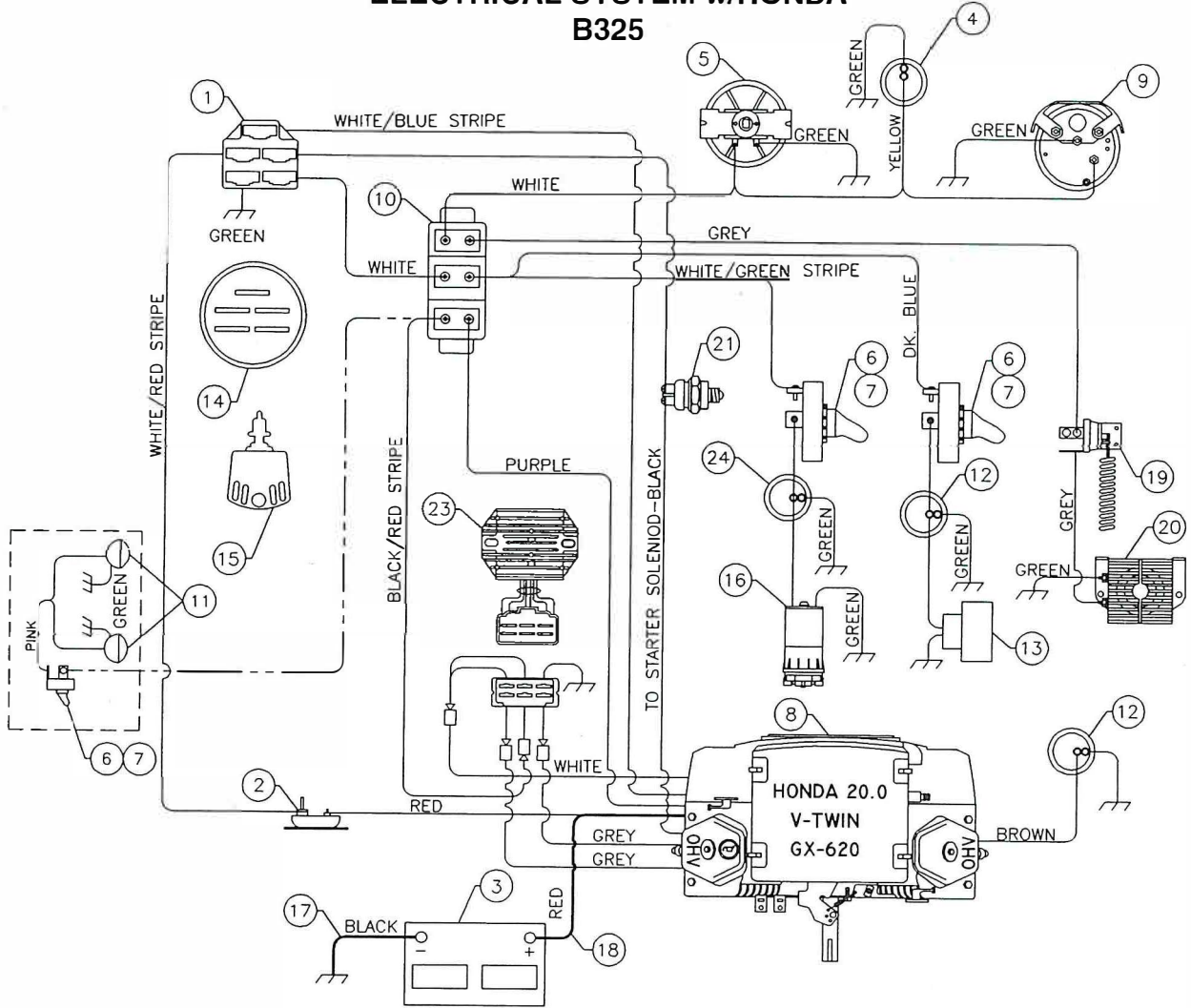
Item No.	Part No.	Description	Qty.
1	000-7119	Rear Spray Bar, PVC	1
2	540-0002	Adapter -Straight, Poly	2
3	542-0003	Adapter - 90° Poly	1
4	542-0002	Adapter - 90° Poly	3
5	530-0001	Ball Valve	2
6	520-0010	Nipple - 1/2" NPT	2
7	523-0001	Tee, 1/2" NPT	1
8	000-7116	Front Spray Bar, PVC	1
9	546-0002	Plug, PVC	1
10	645-0008	Clamp.....	4
11	645-0019	U-Bolt.....	2
12	000-1138	Water Tank - 50 gallon.....	1
13	350-0004	Vented Cap	1
13	350-0020	Vented Cap with chain.....	1
14	524-0004	Adapter - 90° Poly	1
15	540-0005	Adapter -Straight, Poly.....	1
16	338-0014	Water Pump.....	1
17	424-0003	Water Hose, 1/2" I.D. x 72" Lg. (Blue)	1
18	424-0003	Water Hose, 1/2" I.D. x 33" Lg. (Blue)	1
19	424-0003	Water Hose, 1/2" I.D. x 30" Lg. (Blue)	1
20	424-0003	Water Hose, 1/2" I.D. x 8 1/2" Lg. (Blue)	1

ELECTRICAL SYSTEM w/KOHLER
B325



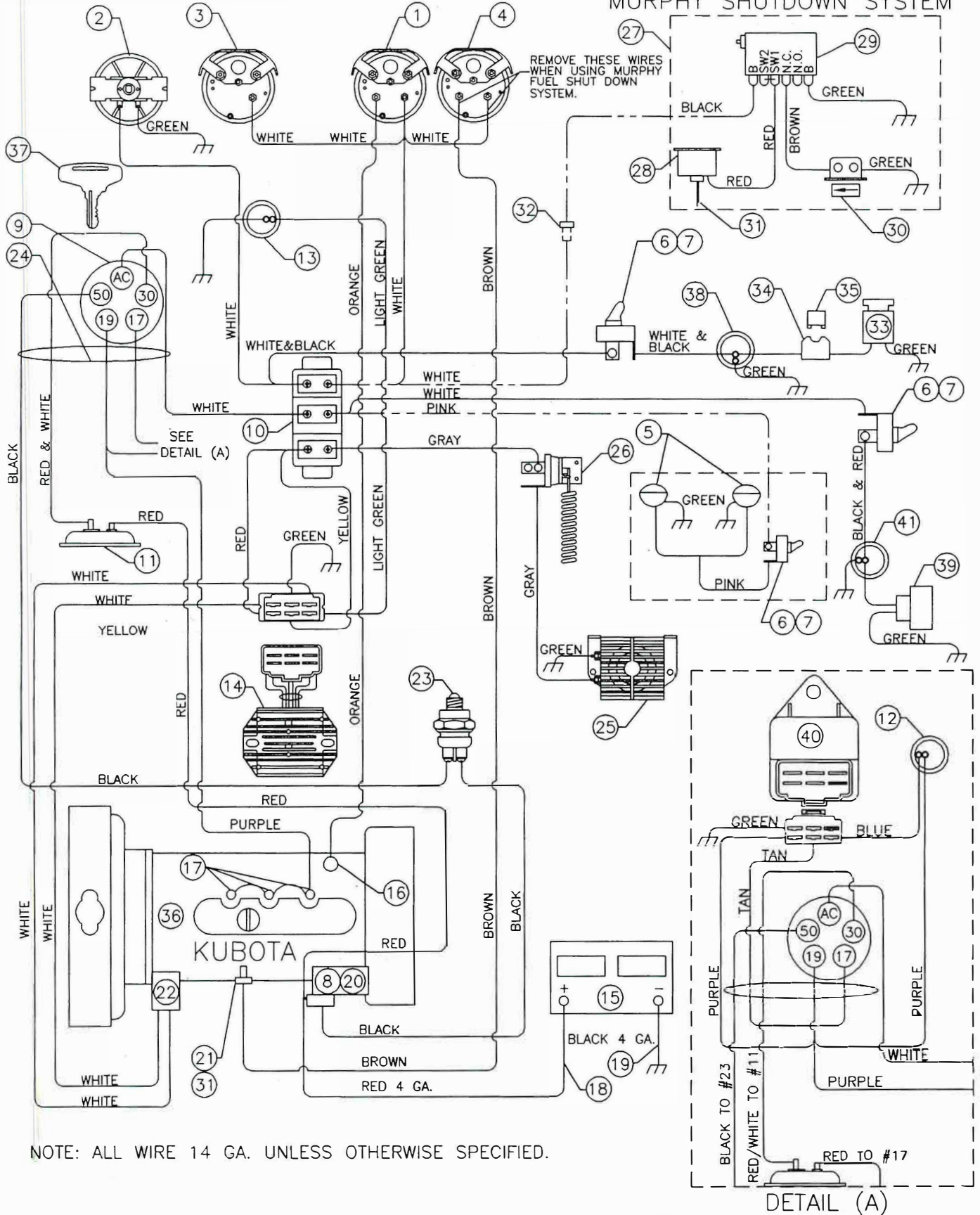
Item No.	Part No.	Description	Qty.
1	335-0074	Connector - 5 pin. Female	1
2	335-0063	Circuit Breaker - 30 Amp Under Dash	1
3	335-0267	Battery - 12 Volt	1
4	335-0019	Green Indicator Light (Key "on")	1
5	375-0001	Hourmeter	1
6	200-0279	Solenoid - On Starter	1
7	335-0071	Toggle Switch - (Parking Brake) & (Water Pump)	2
8	335-0067	Rubber Boot.....	2
9	200-0309	Engine - Kohler CH22S Model (Gas).....	1
10	375-0013	Voltmeter	1
11	335-0021	Terminal Block - Under Dash.....	1
12	335-0105	Red Indicator Light - (Low Oil Warning) & (Brake "on")	2
13	335-0007	Amber Indicator Light (Water Pump "on")	1
14	110-0052	Brake Valve	1
15	335-0047	Ignition Switch - 5 Pole w/key	1
16	335-0064	Spare Keys (Set of 2).....	1
17	338-0014	Water Pump.....	1
18	200-0262	Starter - CH22S	1
19	335-0075	Connector - 5 pin Male.....	1
20	335-0271	Battery Cable Neg Black 12" long	1
21	335-0270	Battery Cable Pos Red 30" long	1
22	335-0094	Switch - Backup Alarm (Optional)	1
23	335-0084	Backup Alarm (Optional)	1
24	335-0013	Switch - Neutral Start (at Control lever)	1
25	335-0172	Work Lights (Optional)	4

**ELECTRICAL SYSTEM w/HONDA
B325**

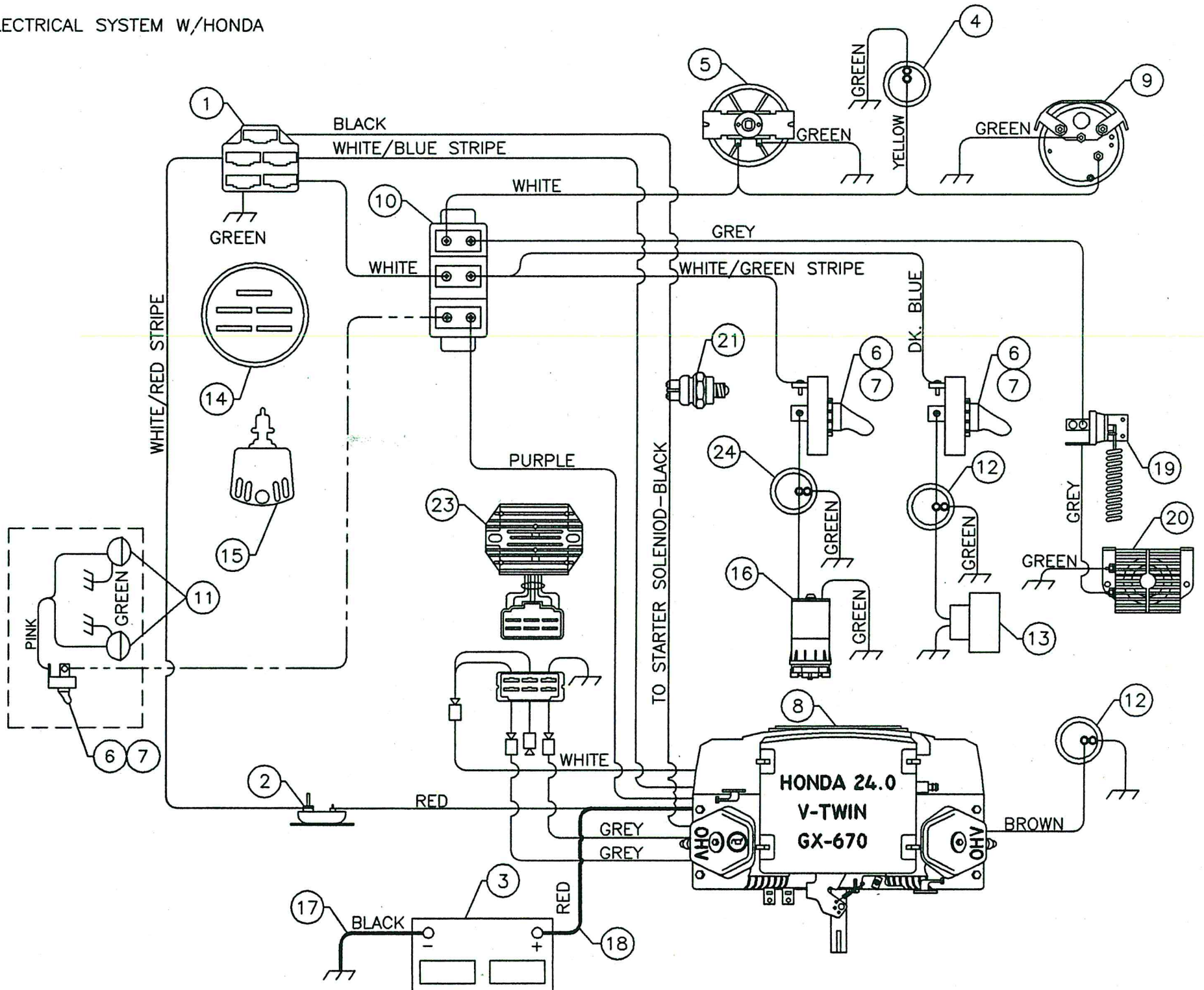


Item No.	Part No.	Description	Qty.
1	335-0074	Connector - 5 pin Female	1
2	335-0063	Circuit Breaker - 30 Amp Under Dash	1
3	335-0267	Battery 12-Volt	1
4	335-0019	Green Indicator Light (Key "on")	1
5	375-0001	Hourmeter	1
6	335-0071	Toggle Switch - (Parking Brake) & (Water Pump)	2
7	335-0067	Rubber Boot.....	2
8	200-0301	Engine, Honda GX620 (Gas).....	1
9	375-0013	Voltmeter.....	1
10	335-0021	Terminal Block - Under Dash.....	1
11	335-0172	Work Lights (Optional)	4
12	335-0105	Red Indicator Light - (Low Oil Warning) & (Brake "on")	2
13	110-0052	Brake Valve	1
14	335-0047	Ignition Switch - 5-pole w/Key	1
15	335-0064	Spare Keys (Set of 2).....	1
16	338-0014	Water Pump.....	1
17	335-0271	Battery Cable Neg. Black 12" Lg.	1
18	335-0270	Battery Cable Pos. Red 30" Lg.	1
19	335-0094	Switch - Back up Alarm (Optional)	1
20	335-0084	Back up Alarm (Optional).....	1
21	335-0013	Switch - Neutral Start (on Control Lever).....	1
22	000-7119	Wire Harness (Not Shown)	1
23	200-0284	Regulator	1
24	335-0007	Amber Indicator Light (Water Pump "on")	1

MURPHY SHUTDOWN SYSTEM

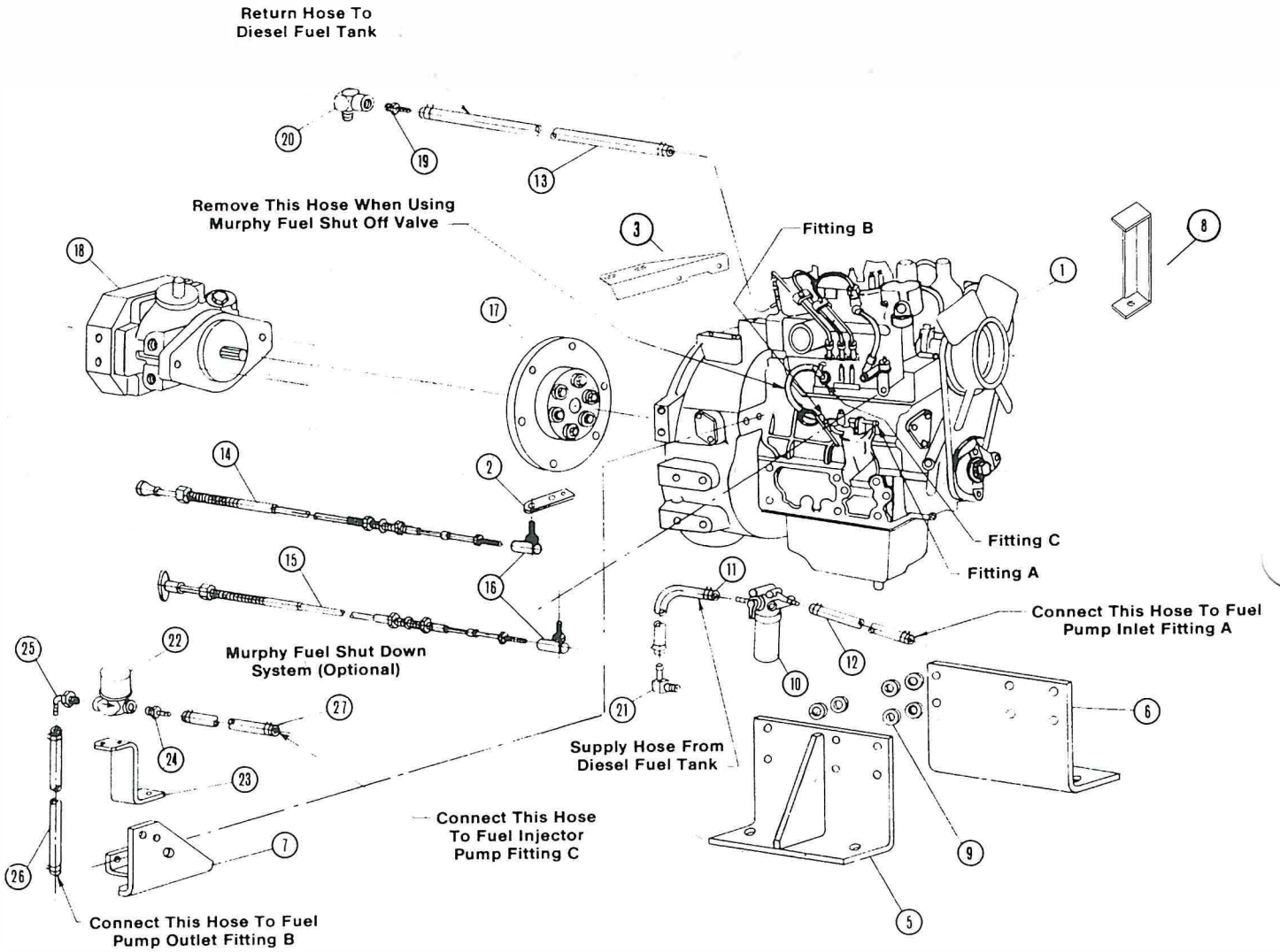


B325 ELECTRICAL SYSTEM W/HONDA



**ELECTRICAL SYSTEM w/KUBOTA DIESEL
B325**

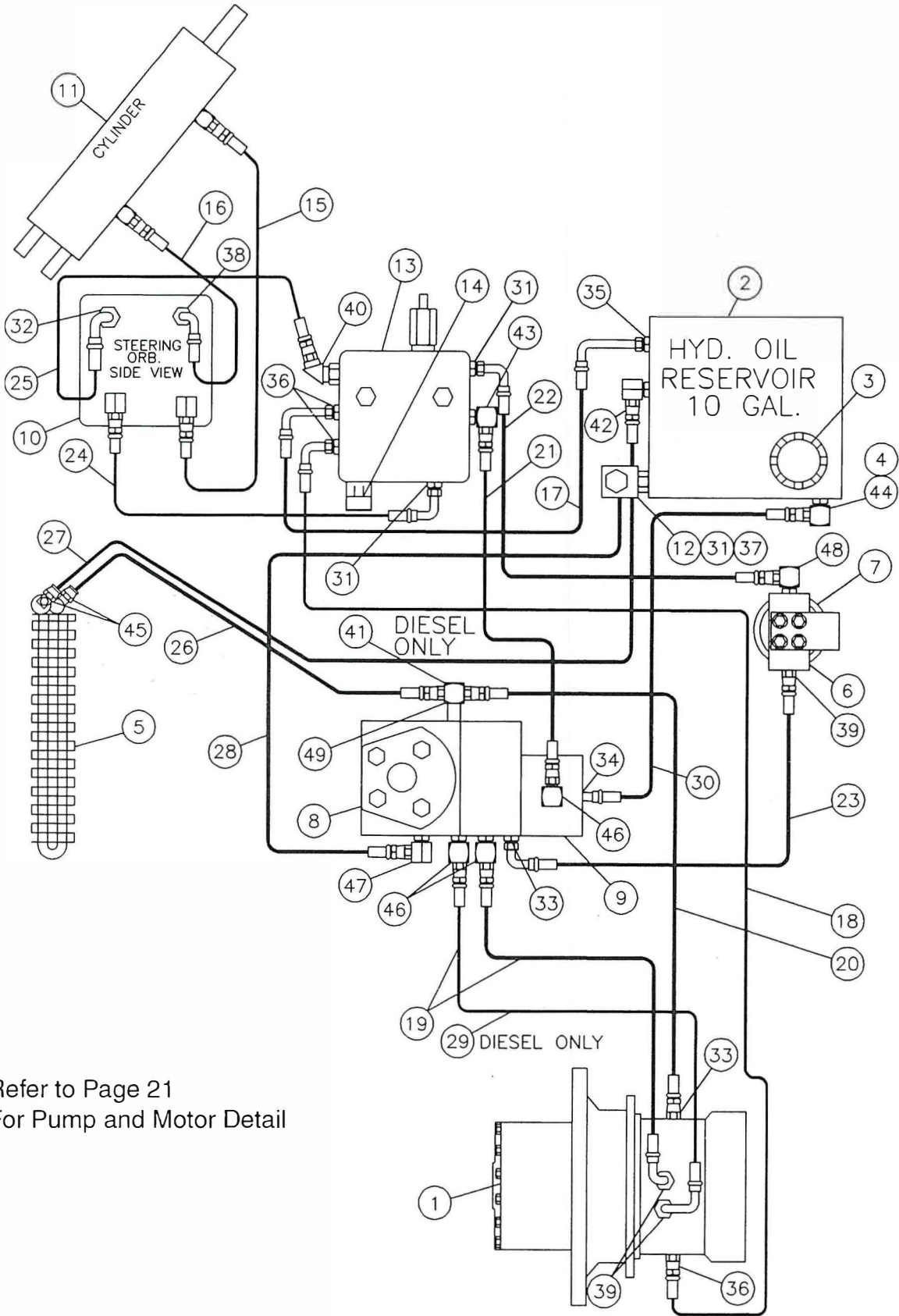
Item No.	Part No.	Description	Qty.
1	375-0003	Water Temp Gauge	1
2	375-0001	Hourmeter	1
3	375-0013	Voltmeter	1
4	375-0023	Oil Pressure Gauge	1
5	335-0172	Work Lights - (Optional).....	4
6	335-0071	Toggle Switch (On-Off)	2
7	335-0067	Rubber Boot - For Toggle Switch	2
8	207-0029	Starter - (Kubota)	1
9	207-0008	Ignition Switch (Kubota).....	1
10	335-0021	Terminal Board	1
11	335-0063	30 Amp Circuit Breaker - Under Dash	1
12	207-0030	Glow Plug Indicator Light - (Kubota)	1
13	335-0019	Green Indicator Light (Key "on")	1
14	207-0018	Voltage Regulator (Kubota)	1
15	335-0267	Battery - 12 Volt	1
16	375-0004	Water Temp Sendor.....	1
17	207-0032	Glow Plug (Kubota)	3
18	335-0270	(POS) Battery Cable (Red)	1
19	335-0271	(NEG) Battery Cable (Black)	1
20	207-0031	Solenoid On Starter (Kubota).....	1
21	375-0024	Oil Pressure Sendor.....	1
22	207-0037	Dyno Alternator (Kubota)	1
23	335-0013	Neutral Start Switch	1
24	000KD556	Wiring Harness	1
25	335-0084	Back Up Alarm - (Optional)	1
26	335-0094	Back Up Alarm Switch -(Optional)	1
27	335-0100	Murphy Fuel Shut Down System Consisting of Items 28, 29, 30, 31, 32 - (Optional)	1
28	375-0015	Murphy Oil Pressure Gauge Replaces Item 4 - (Optional)	1
29	375-0016	Murphy Magnetic Switch - (Optional).....	1
30	375-0017	Murphy Fuel Shut-Off Valve - (Optional)	1
31	375-0018	Murphy Oil Line Kit Replaces Item 21 - (Optional).....	1
32	335-0239	14 Amp Fuse - Murphy - (Optional)	1
33	338-0014	Water Pump	1
34	335-0177	Fuse Holder - (Optional)	1
35	335-0207	10 Amp Fuse - Water Pump - (Optional)	1
36	205-0162	Kubota Diesel Engine - D722.....	1
37	335-0133	Spare Ignition Keys - (Set of 2)	1
38	335-0007	Amber Indicator Light (Water Pump "on")	1
39	110-0052	Brake Valve	1
40	207-0028	Lamp Timer - (Kubota).....	1
41	335-0105	Red Indicator Light (Brake "on").....	1



**KUBOTA D722 DIESEL ENGINE & RELATED COMPONENTS
B325**

Item No.	Part No.	Description	Qty.
1	205-0162	Kubota Diesel Engine Model D722 21 HP	1
2	000KD500	Stop Lever Extension.....	1
3	000-7105	Air Cleaner Bracket	1
5	000KD535	Engine Bracket - Right Hand	1
6	000KD536	Engine Bracket - Left Hand	1
7	000KD526	Bracket For Throttle And Shut Off Cable	1
8	000-7077	Center Floor Cover Support Angle.....	1
9	610-1007	M10 Metric Washers (.590 I.D. x .826 O.D. x .078 T.).....	8
10	205-0011	Fuel Filter (Kubota)	1
11	422-0001	Fuel Line, 5/16" x 17" Lg. SAE (From Tank)	1
12	422-0001	Fuel Line, 5/16" x 14" Lg. SAE (To Fuel Pump Inlet).....	1
13	420-0001	Fuel Line, 3/16" x 18" Lg. SAE (Return).....	1
14	315-0020	Engine Shut Off Cable	1
15	315-0021	Throttle Cable	1
16	645-0026	Ball Joint	2
17	230-0041	Pump & Flywheel Coupling - Consists of (230-0036 Nylon Flange) (230-0037 Splined Hub)	1
18	100-0027	Propel Pump. SEE HYDRAULIC DIAGRAM	1
19	500-0015	Straight Adapter 1/4" NPT x 5/16" Barb	1
20	502-0014	Adapter 90° 1/4" NPT Male x 1/4" NPT Female.....	1
21	502-0021	Adapter 90° 1/4" NPT x 5/16" Barb	1
22	335-0100	Fuel Shut Down System (Murphy) - (Optional)	1
23	000KD518	Bracket For Fuel Shut-Off Valve (Murphy) - (Optional).....	1
24	500-0015	Straight Adapter 1/4" NPT x 5/16 Barb - (Optional)	1
25	502-0021	Adapter 90° 1/4" NPT x 5/16 Barb - (Optional).....	1
26	422-0001	Fuel Line 5/16" x 4" Lg. SAE - (Optional).....	1
27	422-0001	Fuel Line 5/16" x 10" Lg. SAE - (Optional)	1

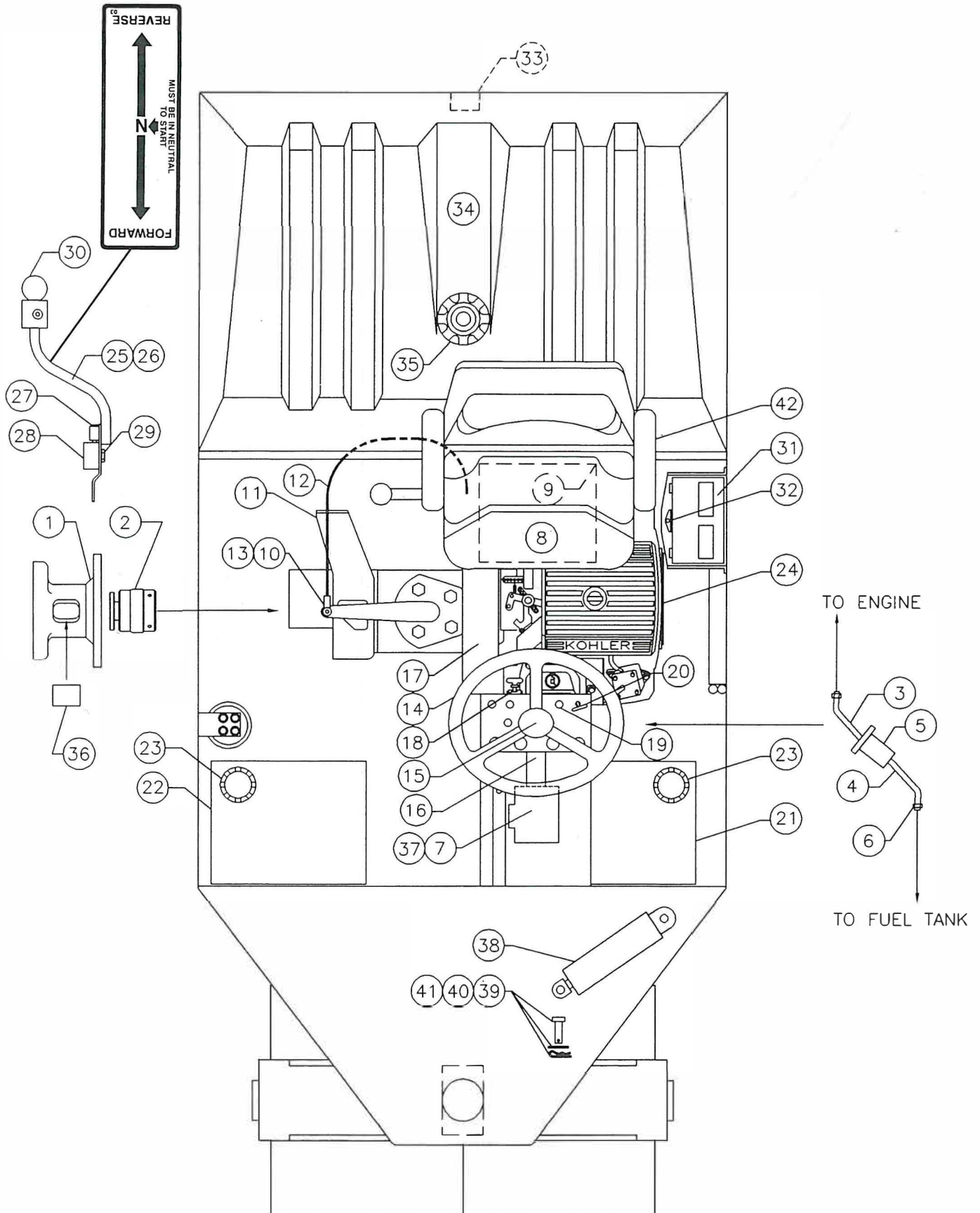
NOTE: Diesel parts shown are those made by Beuthling Manufacturing Co. or Kubota engine parts that have been altered by Beuthling Manufacturing Co. See Kubota Parts List for remaining engine parts.



Refer to Page 21
For Pump and Motor Detail

HYDRAULIC SYSTEM
B325

Item No.	Part No.	Description	Qty.
1	105-0030	Drive Motor w/Brake	1
2	000-7049	Tank, Hydraulic Oil - 10 US gal.....	1
3	350-0002	Fill Cap w/Screen.....	1
4	130-0006	Strainer - Suction.....	1
5	125-0003	Heat Exchanger	1
6	130-0017	Filter Head	1
7	130-0016	Filter Element.....	1
8	100-0027	Pump, Propel.....	1
9	100-0028	Pump, Steering	1
10	105-0008	Motor, Steering Orbital.....	1
11	115-0007	Cylinder, Hydraulic.....	1
12	110-0051	Check Valve	1
13	110-0050	Valve Block	1
14	110-0052	Brake Valve	1
15	403-0041	Hose Assembly 3/8" ID x 32 1/2" Lg.	1
16	403-0042	Hose Assembly 3/8" ID x 32 1/2" Lg.	1
17	403-0043	Hose Assembly 3/8" ID x 20" Lg.	1
18	403-0044	Hose Assembly 3/8" ID x 77" Lg.	1
19	404-0049	Hose Assembly 1/2" ID x 35" Lg.	2
20	404-0050	Hose Assembly 1/2" ID x 40" Lg.	1
21	404-0051	Hose Assembly 1/2" ID x 35" Lg.	1
22	404-0052	Hose Assembly 1/2" ID x 42" Lg.	1
23	404-0053	Hose Assembly 1/2" ID x 16" Lg.	1
24	404-0054	Hose Assembly 1/2" ID x 35 1/2" Lg.	1
25	404-0055	Hose Assembly 1/2" ID x 34 1/2" Lg.	1
26	404-0056	Hose Assembly 1/2" ID x 34" Lg.	1
27	404-0057	Hose Assembly 1/2" ID x 36" Lg.	1
28	404-0058	Hose Assembly 1/2" ID x 31 1/2" Lg.	1
29	404-0059	Hose Assembly 1/2" ID x 40" Lg. (Diesel only)	1
30	406-0017	Hose Assembly 3/4" ID x 23" Lg.	1
31	500-0001	Adapter Straight.....	3
32	500-0004	Adapter Straight.....	1
33	500-0016	Adapter Straight.....	2
34	500-0037	Adapter Straight.....	1
35	500-0054	Adapter Straight.....	1
36	500-0068	Adapter Straight.....	3
37	500-0073	Adapter Straight.....	1
38	500-0074	Adapter Straight.....	1
39	500-0075	Adapter Straight.....	3
40	501-0007	Adapter 45°	1
41	501-0014	Adapter 45° (Diesel only).....	1
42	502-0003	Adapter 90°	1
43	502-0010	Adapter 90°	1
44	502-0022	Adapter 90°	1
45	502-0024	Adapter 90°	2
46	502-0031	Adapter 90°	3
47	502-0051	Adapter 90°	1
48	502-0052	Adapter 90°	1
49	503-0020	Adapter Tee	1

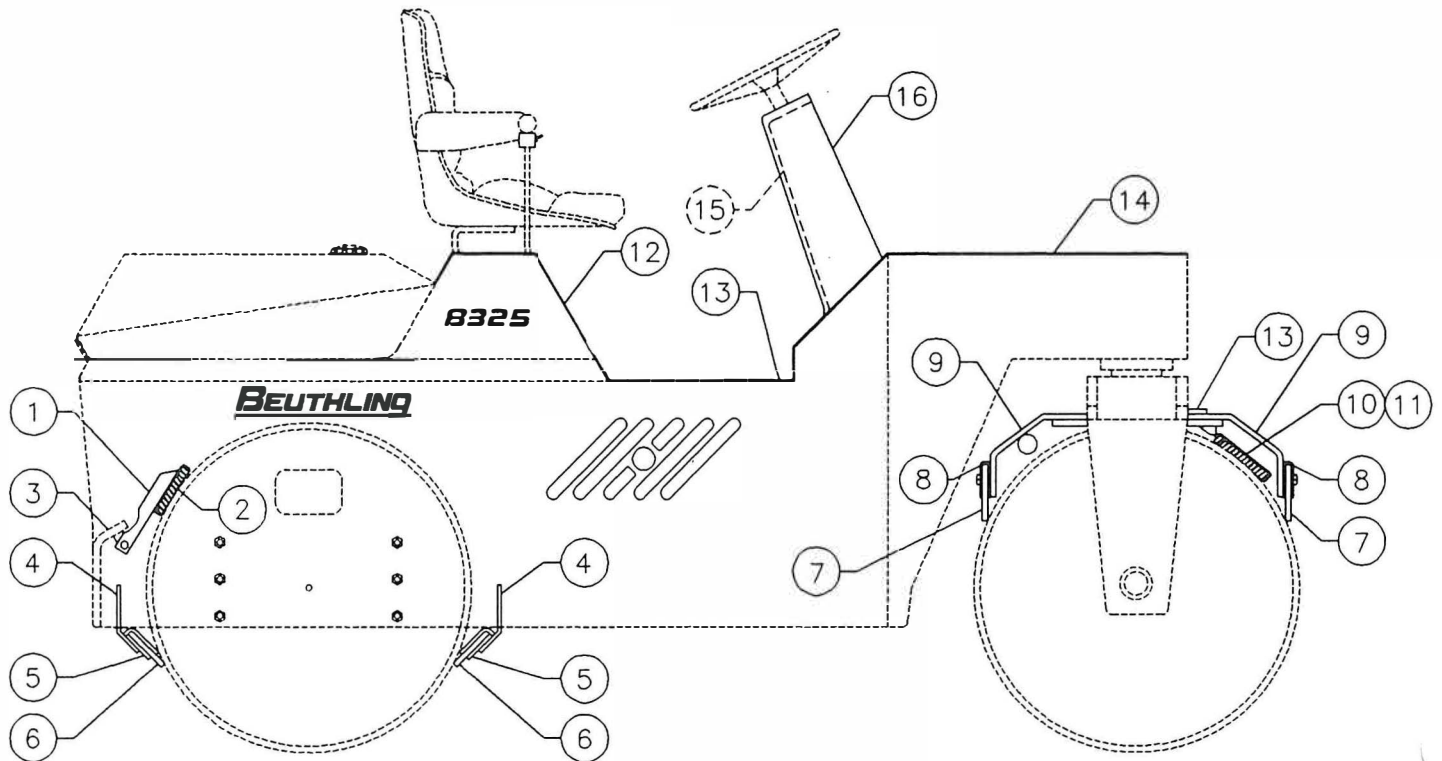


MISCELLANEOUS COMPONENTS - B325

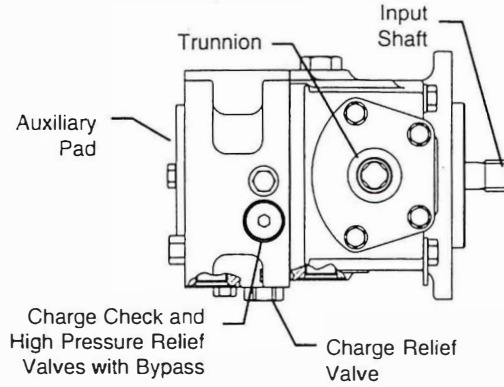
Item No.	Part No.	Description	Qty.
1	345-0003	Pump Mount (Kohler Engine).....	1
1	345-0001	Pump Mount (Honda Engine)	1
2	230-0046	Coupling (Pump to Kohler Engine)	1
2	230-0047	Coupling (Pump to Honda Engine)	1
3	431-0001	Fuel Line, 1/4" x 4" Lg. SAE.....	1
4	431-0001	Fuel Line, 1/4" x 10" Lg. SAE.....	1
5	200-0027	Filter, Kohler Fuel.....	1
6	500-0009	Adapter, 90° Barbed	1
7	000-7089	Bracket, Orbital Mounting	1
8	395-0001	Seat	1
9	000-1240	Seat Base	1
10	000-7080	Lever, Pump Control	1
11	000-7075	Plate, Pump Control Base	1
12	315-0011	Cable, Pump Control	1
13	645-0022	Ball Joint	2
14	330-0011	Steering Wheel	1
15	330-0005	Cap, Steering Wheel	1
16	330-0014	Column, Steering Wheel	1
17	000-3043	Heat Duct (Kohler Engine).....	1
17	200-0245	Muffler (Kohler Engine)	1
17	000-7125	Exhaust Pipe (Kohler Engine)	1
17	200-0305	Muffler (Honda Engine)	1
17	000-7126	Exhaust Pipe (Honda Engine)	1
18	645-0064	Latch, Rubber Hood (with Hardware)	1
19	315-0001	Cable, Choke (Gas Engine).....	1
20	315-0019	Cable, Throttle (Gas Engine).....	1
21	000-7046	Tank, Fuel	1
22	000-7072	Tank, Hydraulic oil	1
23	350-0002	Fill Cap with Screen.....	2
24	200-0309	Engine, Kohler Gas - 22HP Model CH22S	1
24	200-0301	Engine, Honda Gas - 20HP Model GX620	1
25	000-7115	Control Lever, complete assembly.....	1
26	000-7121	Control Lever, lever only	1
27	310-0005	Spring Plunger, Control Lever	1
28	000-1438	Mount, Control Lever	1
29	000-1440	Adjusting Bolt, Control Lever	1
30	350-0009	Knob, Black Plastic	1
31	335-0267	Battery - 12 Volt, side terminals.....	1
32	385-0074	Hold Down, Battery	1
33	335-0084	Back Up Alarm (Optional)	1
34	000-1138	Tank, Polyethylene Water (50 gal.)	1
35	350-0020	Cap w/Chain, Water Tank (cap only 350-0004).....	1
36	350-0006	Protective Cover	1
37	105-0008	Motor, Steering Orbitol.....	1
38	115-0007	Cylinder, Hydraulic Steering	1
39	000-7010	Pin, Steering Cylinder	2
40	620-0011	Washer	2
41	630-0010	Cotter Pin.....	2
42	395-0002	Arm Rest	2

COVERS, DRUM RUBBER SCRAPERS AND COCOA MATS

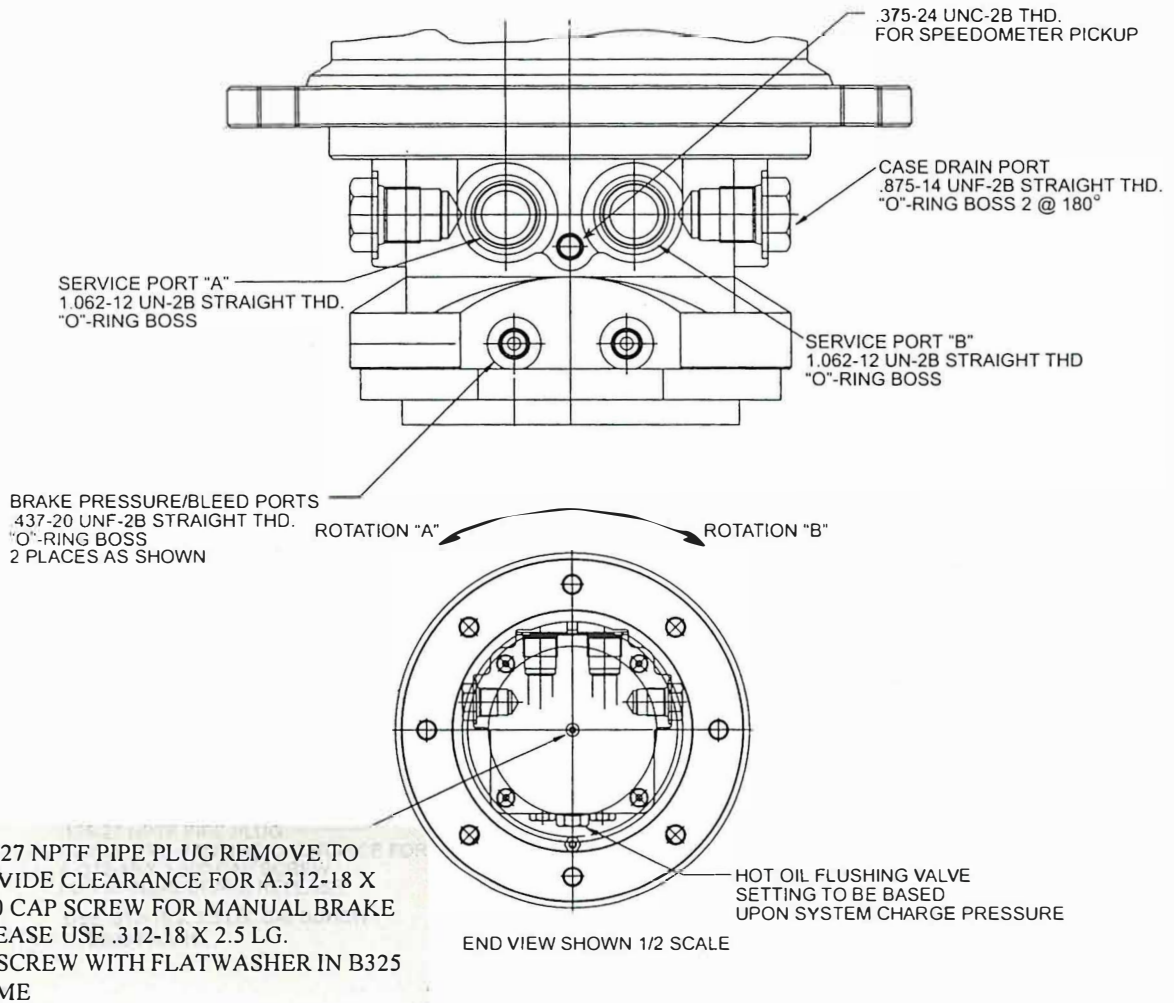
Item No.	Part No.	Description	Qty.
1	000-1294	Rear Cocoa Mat Pan	1
2	355-0003	Rear Cocoa Mat.....	1
3	000-1271	Rear Cocoa Mat Pivot Bracket.....	2
4	000-1277	Bracket - Scraper Rear Drum	4
5	000-1278	Back Up Bar - Rear Scraper	4
6	000-1279	Rear Rubber Scraper.....	2
7	000-7097	Front Rubber Scraper	2
8	000-7098	Back Up Bar - Front Rubber Scraper.....	4
9	000-1270	Front Scraper Arm	4
10	000-7030	Front Cocoa Mat Pan.....	1
11	355-0019	Front Cocoa Mat	1
12	000-7067	Rear Floor Cover	1
13	000-7069	Center Floor Cover	1
14	000-7057	Front Floor Cover.....	1
15	000-7034	Steering Column Dash Panel.....	1
16	000-7065	Steering Column cover	1



PROPEL PUMP (P/N 100-0027)



DRIVE MOTOR W/BRAKE (P/N 105-0030)



SPECIFICATIONS

WEIGHTS

Shipping Weight..... 3900 lbs.
Operating Weight (Full Ballast + Operator) 6000 lbs.

DIMENSIONS

Overall Length..... 110 in.
Overall Height 71 in.
Overall Width..... 45 in.
Wheelbase..... 75 in.
Curb Clearance 12 in.
Wall Clearance 1.75 in.

CAPACITIES

Fuel 8 gal.
Hydraulic Fluid..... 10 gal.
Engine Oil 4 pts.
Water Tank 50 gal.

DRUM

FRONT:

Type(split) steel machined surface w/ballast fill plug
Overall Width..... 32 in.
Diameter 30 in.
Shell Thickness500 in.
Oscillation 24° Total

REAR:

TypeSteel, machined surface
Overall Width..... 41 in.
Diameter 30 in.
Shell Thickness500 in.

STEERING

Type Hydraulic, cylinder-front drum
Turning Radius (outside)..... 16.5 ft.
Turning Radius (inside) 10 ft.
Occillation +/- 12

DRIVE

Drive System Hydrostatic, Internal Direct Drive,
Rear Drum, Single Lever,
Infinitely Variable Controls
Travel Speed 0-7 MPH
Engine Kohler 22 HP OHV command Twin Cylinder,
Air Cooled (gasoline), Electric Start, 12 Volt Battery

BRAKES

ServiceHydrostatic drive provides dynamic braking
Secondary/ParkingFailsafe, Spring applied
Hydraulically released, manual switch on console

WATER SPRAY SYSTEM

Type....Pressurized w/electric pump and dual ball valves
Tank Polyethylene, 3" fill neck,
Cap w/safety chain rear, 50 gal. capacity
Drum Scrapers Four, adjustable rubber
Drum Cocoa Mats One each drum, pivoting

STANDARD EQUIPMENT

- Gauges.....Hourmeter, Voltmeter & Low Oil Indicator Light
- SeatHigh Back, Bucket Type w/Arm Rests, Adjustable
- Safety Devices..... Neutral Start Switch
- Transmission BypassTowing Valve

OPTIONAL EQUIPMENT

- *Special Paint*
- *Back-up Alarm*
- *Vandal Protection Package*
- *Kubota Diesel Engine, water cooled, 3 cylinder, 21 HP*
- *Honda Gas Engine 20 HP*
- *Fuel Gauge, on Dash*
- *Work Lights*
- *ROPS (Rollover Protection Structure) w/seat belt*



ONE YEAR LIMITED WARRANTY

We warrant to the original consumer that each new unit sold by us will be free from manufacturing defects in materials or workmanship in normal service for a period of one year from date of shipment, provided the unit is operated and maintained in accordance with BEUTHLING MANUFACTURING'S instruction and manuals.

Defective parts are to be returned to the factory, freight prepaid, and will be replaced or repaired whichever BEUTHLING MANUFACTURING COMPANY elects. Some components, i.e., engine, hydraulic pumps and motors etc. are subject to manufacturer's warranty. Most of these warranties meet or exceed the BEUTHLING WARRANTY.

For the first 12 months, BEUTHLING MANUFACTURING COMPANY will cover all parts and labor. After the first six months, rental units and the following specific components are not covered under the BEUTHLING WARRANTY: batteries, electrical components, throttle, choke, & control cables.

This warranty is not applicable to normal maintenance service (such as engine tune-ups) or normal replacement of service or wear items, such as filters, lubricating oil, grease and rubber scrapers.

Allowance for repairs or alterations will not be allowed unless they are authorized in writing by BEUTHLING MANUFACTURING COMPANY.

Liability for damages or delay caused by defective parts will not be assumed by BEUTHLING MANUFACTURING COMPANY.

Credit will not be allowed if in the opinion of BEUTHLING MANUFACTURING COMPANY a part failed through neglect of maintenance, misuse or as the result of an accident. The machine may not be altered or modified in any manner which affects the mechanical operation of the machine as designed by the manufacturer.

BEUTHLING MANUFACTURING COMPANY makes every effort to continually improve its products, and it does so without incurring any obligation to make such changes on units previously shipped. BEUTHLING MANUFACTURING COMPANY also reserves the right to discontinue the production of any product at any time.

To obtain warranty service, purchaser must bring the unit to an authorized BEUTHLING dealer.

New Beuthling
465 Griffin Blvd.
Amery, Wisconsin 54001
715-263-2300

NOTES

NOTES

MACHINE IDENTIFICATION INFORMATION

MACHINE SERIAL NUMBER: _____

ENGINE MAKE, MODEL & SERIAL NUMBER: _____

PURCHASE DATE: _____

DISTRIBUTOR: _____

MACHINE SERVICE INFORMATION